

Work Order ID 63154

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Thursday, October 21, 2010 3:54:54 PM

Item ID: D350-578-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 10/21/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/28/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-10-22

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2432

Rev F3

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-578-011 CHG005

Siola 1/9

OK Per BGR 10/11/18

160

0.00



Packaging

Pick Kit

Memo

0.00

Packaging

10/11/19 42 SP

170

0.00



QC

QC4- 100% Inspect kits for completeness

Memo

0.00

Quality Control

Siola 1/2

(X8)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

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Item ID: D350-578-011

Accept

Revision ID:

Item Name: Bearpaw



Start Date: 10/21/2010 Start Qty: 4.00

Required Date: 10/28/2010 Req'd Qty: 4.00

Reference:


Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 180  Packaging | Packaging | 0.00 | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | Identify and pack for shipping as per PPP 011 □ Location: <u>11</u> | D350-578- | | | | | | | |
| | | | | | | | | | |
| 190  QC | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| Quality Control | Memo | 0.00 | | | | | | | |

Reva

10/11/19 SF 

OK 10/11/22 
mf
10-11-19

| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 63154

Parent Item: D350-578-011

Parent Item Name: Bearpaw



Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-01-02 JLM
IPP Rev:B 08-01-09 Added Step 2 JLM Verified By:EC
IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|---------------------|--|-----------|----|--|--|-----|------|----------|----|----|--|--|--|
| AN4-17A Bolt | | Purchased | No | | | 160 | Each | 422.0000 | 12 | 48 | | | |
|---------------------|--|-----------|----|--|--|-----|------|----------|----|----|--|--|--|

Location Loc Qty Loc Code

ST359 422

112314 422

| | | | | | | | | | | | | | |
|------------------------------|--|--------------|----|--|--|-----|---|----------|-----|----|--|--|--|
| D2182B Rubber Cushion | | Manufactured | No | | | 160 | f | 152.9192 | 2.5 | 10 | | | |
|------------------------------|--|--------------|----|--|--|-----|---|----------|-----|----|--|--|--|

Location Loc Qty Loc Code

ST402A 22.77

30872 13.67

39986 9.1

ST410 130.14924

52649 130.14924

| | | | | | | | | | | | | | |
|--|--|--------------|----|--|--|-----|------|----------|----|----|--|--|--|
| Cut qty 6 at 5.00" long D2274 Radius Block | | Manufactured | No | | | 160 | Each | 106.0000 | 12 | 48 | | | |
|--|--|--------------|----|--|--|-----|------|----------|----|----|--|--|--|

Location Loc Qty Loc Code

ST010 106

59108 4

61361 102

→ measure
S101119

10/11/10

48

B63413 10/11/10

B62658 10/11/10 40

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 63154



Parent Item: D350-578-011



Parent Item Name: Bearpaw

Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 4.00

Required Qty: 4.00

D2432

Manufactured No

160

Each

1.0000

2

8



206 (24") Bearpaw



63/22 *Rec'd 10/18*

Location

Loc Qty

Loc Code

ST495

1

52526

1

D2438

Manufactured No

160

Each

179.0000

6

24



Clamp



10/11/19 sl

Location

Loc Qty

Loc Code

ST456

179

60852

179

D2529

Manufactured No

160

Each

481.0000

12

48



Washer



24
10/11/19 sl

Location

Loc Qty

Loc Code

ST017

481

61979

481

MS21042L4

Purchased No

160

Each

3,253.000

12

48



Nut



48
10/11/19 sl @

Location

Loc Qty

Loc Code

ST300

3253

113422

68

114523

8

114718

16

114784

32

115108

129

115589

1900

115621

1100

48

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Shop Packet Print

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 63154



Parent Item: D350-578-011



Parent Item Name: Bearpaw

Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0463J

Purchased

No

160

Each

514.0000

24

96



Washer



M116025 10/11/2010

Location

Loc Qty

Loc Code

ST298

514

10096

10

114576

68

115622

320

115647

116

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

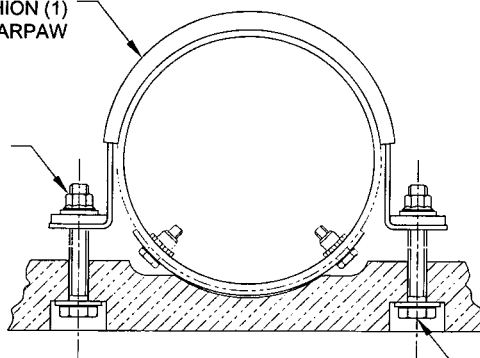
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

D2438 CLAMP (1)
D2182B050 RUBBER CUSHION (1)
3 PL PER BEARPAW

MS21042L4 NUT (1)
AN960JD416 WASHER (1)
D2274 RADIUS BLOCK (1)
D2529 WASHER (1)
AN4-17A BOLT (1)
6 PL PER BEARPAW



REFERENCE ONLY

ADDITIONAL AN960JD416 WASHERS MAY BE INSTALLED UNDER THE NUTS TO ENSURE 1.5-4 THREADS IN SAFETY ON THE BOLTS. ALTHOUGH NOT GENERALLY NECESSARY, IT IS ALSO ACCEPTABLE TO REPLACE THE AN4 BOLTS PROVIDED WITH LONGER OR SHORTER AN4 BOLTS, IF REQUIRED.

Section A-A
Figure 4 - Clamping Detail

5.0 PARTS LIST

| Qty -011 | Qty -021 | Part Number | Description |
|-------------|-------------|--------------|----------------------|
| X | | D350-578-011 | BEARPAW INSTALLATION |
| | X | D350-578-021 | BEARPAW INSTALLATION |
| 6 | 6 | D2182B050 | Rubber Cushion |
| 12 | 12 | D2274 | Radius Block |
| 12 | 12 | D2529 | Washer |
| 6 | 6 | D2438 | Clamp |
| 2 | | D2432F | Bearpaw |
| | 2 | D2672F | Bearpaw |
| 12 | 12 | AN4-17A | Bolt |
| 24 | 24 | AN960JD416 | Washer |
| 12 | 12 | MS21042L4 | Nut (or MS21042-4) |